

Date: Thursday, 22/01/2009 10:27:52 AM
User: Melanie Fauteux

Green

Dart Aerospace Ltd.

Process Sheet

TULLMAR

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 45008
Estimate Number : 13391
P.O. Number :
This Issue : 22/01/2009 S.O. No. :
Prsht Rev. : NC
First Issue : 22/01/2009 Type : SMALL /MED FAB
Previous Run : 41516
Written By :
Checked & Approved By : MF 09-01-22
Comment : est rev A new issue 08.06.19 EC verified: DD

Drawing Name : SHORT D-PAD ASSY
Part Number : PB674300183
Drawing Number : B67-43001 P.12
Project Number : N/A
Drawing Revision : B1
Material :
Due Date : 28/01/2009 Qty: 26 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PB6743001185 D-Pad Back Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 26.0000 Each(s)

D-Pad Back Plate

batch: 107387

MF 09-01-26

2.0 PB6743001189 D-Pad Face



Comment: Qty.: 1.0000 Each(s)/Unit Total : 26.0000 Each(s)

D-Pad Face

batch: 41567

MF 09-01-26

3.0 PB6743001193 D-Pad Base



Comment: Qty.: 1.0000 Each(s)/Unit Total : 26.0000 Each(s)

D-Pad Base

batch: 41569

MF 09-01-26

4.0 PB6743001339 D-Pad Top



Comment: Qty.: 1.0000 Each(s)/Unit Total : 26.0000 Each(s)

D-Pad Top

batch: 41575

MF 09-01-26

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble and weld as per dwg B67-43001 (QSI004)

MF 09-01-28

(x26)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 22/01/2009 10:27:52 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT D-PAD ASSY

Job Number: 45008

Part Number: PB674300183

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush only on side of -193

SAD 09-01-29

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-01-29

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-01-29 (26)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:15
320 OF
3:45

M102 316

(26x)

M-F 09/01/30

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-F 09-02-02

11.0

PG

PURCHASING



Comment: SEND TO TALMAR FOR FOAM AND FABRIC

710:
8103

09/02/02 (26)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

09/02/12 (26)

13.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

09-02-13 (26)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT D-PAD ASSY

Job Number: 45008

Part Number: PB674300183

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST.

Blade Fold section

MF 09-02-13

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/17 MF

Job Completion



MF
09-02-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

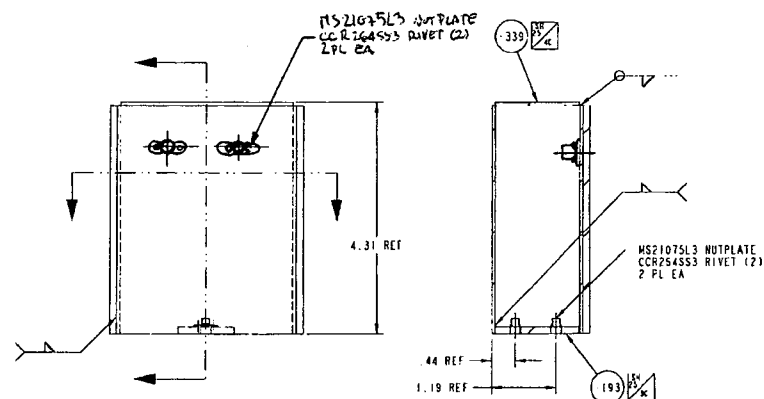
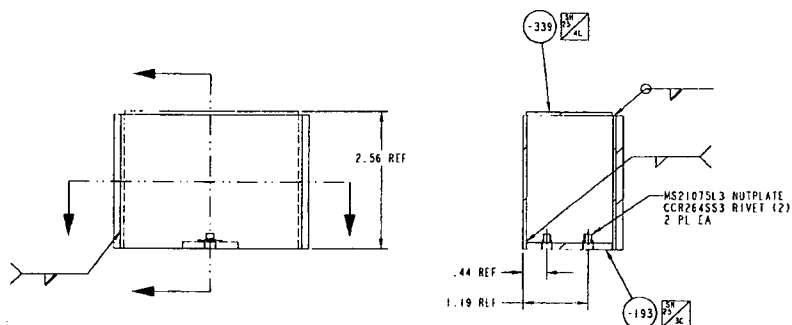
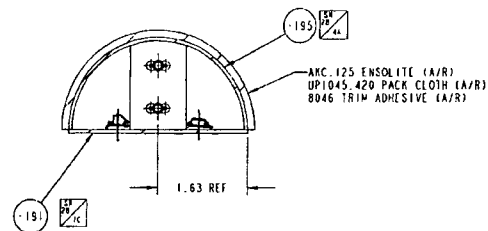
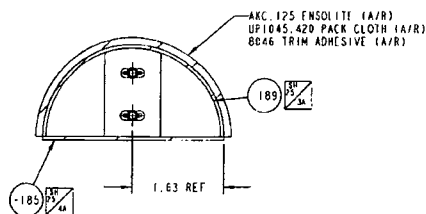
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
4-2-61



⑥ -83 SHORT D-PAD ASSEMBLY SCALE 1.000

② -85 LONG D-PAD ASSEMBLY SCALE 1.000

45008

PACKING SLIP

TULMAR

Tulmar Safety Systems Inc.
1123 Cameron Street
Hawkesbury, ON K6A 2B8 CA
Tel: 613-632-1282
Fax: 613-632-2030
MID : XOTULSAF1123HAW
email: info@tulmar.com

Bill No:

Dart Aerospace
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7. Canada

Packing Slip No.

31577

Ship Date

12-Feb-09

Ship To:

Dart Aerospace
1270 Aberdeen Street
Buyer: C Lavoie 613-632-9577
Hawkesbury, ON K6A 1K7. Canada
613-632-9577

Order number	Sales order date	Account number	Account manager
22689	2-Feb-09	CDART100	Barney Bangs
PO number		Ship Via	PPD/COL
PO00008103		Company Truck	
Item No.	Quantity ordered	UOM	Qty Shipped/Returned
Description			Quantity on back order

8421-100
Dart Blade Fold Kit-Pad #1/
Drawing No: (Ref D3449 (P/N D3449-1 RevA))
DWG Rev: A
Lot No: BATCH0000000004 Qty: 10

10 EA 10

8421-101
Dart Blade Fold Kit - Pad #2/
Drawing No: (Ref B67-43001-83 Rev B1)
DWG Rev: NR
Lot No: BATCH0000000004 Qty: 26

26 EA 26

8421-102
Dart Blade Fold Kit - Pad #3/
Drawing No: (Ref B67-43001-85 Rev B1)
DWG Rev: NR
Lot No: BATCH0000000005 Qty: 20

20 EA 20

Shipper

Date:

FEB 12 2009

Certificate of Conformance

☐ Not Applicable

I hereby certify that the items listed hereon have been inspected tested and conform to all specifications and requirements detailed in the contract or purchase order. Objective evidence to support this statement is on file and can be made available upon request
If any questions or concerns, please contact QA Manager @ 613-632-1282 ext. 245.

Authorized Inspector

Date: 02/12/2009